

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000695**Date Inspected:** 12-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-up 89 M and OBG weld trial**Summary of Items Observed:**

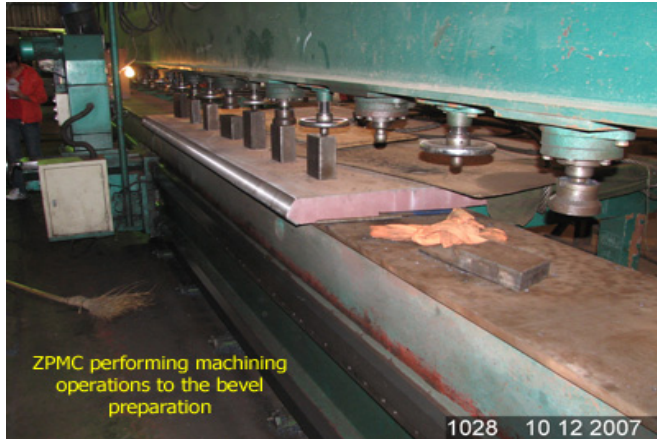
CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the fabrication of the Mock-ups scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

**Tower Mock-up 89 Meter Elevation**

In cursory visit to the Tower Mock-up shop the QA inspector observed ZPMC performing welding operations on the skin D lower section at the junction of the plate mp506 to the MA22 with the submerged arc welding (SAW) process. Also, The QA inspector observed that ZPMC performing machining operations at the bevel from the skin plates. See digital photograph below.

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Item	Description	WBS	Dwg No.	Status
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1	OBG Weld Trial			
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The QA inspector observed that ZPMC was performing grinding operations at the U-ribs designated as U-95, U-6, U-21, U-41 and U-3. The QA performed dimensional inspections to the root face, bevel angle and total length to the above mentioned U-ribs. The QA inspector witnessed ZPMC performing flatness, straightening, high and U-rib profile verifications on the U rib U-21.

The QA inspector had a conversation with Caltrans Task Leader Mr. Robert Cuellar. Mr. Robert Cuellar voiced to the QA inspector that ZPMC cancelled the dimensional inspections to the U rib U-95, U-6, U-21, U-41 and U-3 because ZPMC would use others U-ribs (U-70, U-74, U-102, U-104 and U-71) for the weld trial.

The digital photographs below show ZPMC grinding the U ribs bevel preparations and performing dimensional verifications

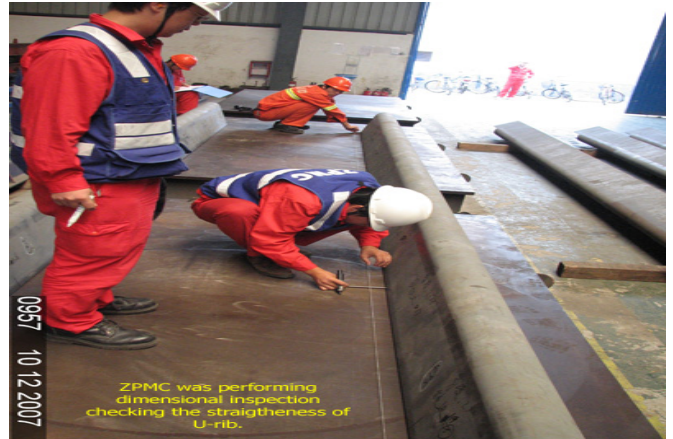


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### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Acuna,Alfredo

Quality Assurance Inspector

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**Reviewed By:** Cuellar,Robert

QA Reviewer